

Table 7

No.	Steel	Hot rolling					Hot-rolled sheet annealing		Cold rolling		Cold-rolled sheet recrystallization annealing		Cooling rate bedrock quenching	Fading		Alloying		Remarks
		Rough rolling		Finish rolling			Cooling °C	Process	Batch Continuous	Reduction ratio %	Temp. °C	Time s		Sheet temp. °C	Bath temp. °C	Temp. °C	Reduction than times	
		HET °C	BDT °C	WET °C	Presence of lubrication	PTT °C												
1	A	1150	800	810	Yes	680	95	810	780	Batch	80.0	680	40	15	470	465		II
2	B	1150	810	830	Yes	680	85	810	840	Continuous	80.0	680	40	-	-	-	-	I
3	C	1140	820	840	Yes	690	85	830	800	Batch	82.5	670	40	30	465	460	460	III
4	D	1150	800	820	Yes	650	85	830	830	Continuous	82.5	680	40	35	470	465	-	II
5	E	1150	830	850	Yes	690	85	830	810	Batch	80.0	680	40	35	465	460	460	III
6	F	1150	820	840	Yes	670	85	830	810	Batch	82.5	680	40	-	-	-	-	I
7	G	1130	810	820	Yes	670	85	830	800	Batch	80.0	670	40	50	480	470	-	II
8	H	1100	800	810	Yes	650	85	800	780	Batch	80.0	680	40	15	465	470	470	III
9	A	1050	800	810	Yes	650	85	800	780	Batch	82.5	680	40	15	470	465	-	II
10	B	1140	810	820	Yes	670	85	820	780	Batch	82.5	680	40	1	470	460	460	III
11	C	1350	1180	1070	Yes	670	85	760	850	Continuous	80.0	670	40	30	465	460	460	III
12	D	1170	800	810	Yes	680	85	810	No intermediate		80.0	680	40	-	-	-	-	I

SRT = slab heating temperature, BDT = rough rolling delivery temperature, FRT = finisher entrance temperature, PTT = finisher delivery temperature,
 CT = cooling temperature, I = cold-rolled steel sheet, II = hot-dip galvanized steel sheet, III = alloying hot-dip galvanized steel sheet